

5/20

DART AEROSPACE LTD	Work Order:	23052
Description: Panel	Part Number:	D3330-7
Dwg: D3330 Rev. A PAGE -6	Qty:	15
Ref: RF 05.01.17	Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PF	05.04.15	15
2	PG	Issue P/O: <u>7007973</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3330 Possible Supplier: Industrial Laser Material release note is required	U	05/04/15	
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CD	05/05/16	15
4	QC6	Inspect dimensions as per Dwg D3330 or D3330-7 T1 TEMPLATE	M	05/05/25	15
5	GA	Deburr	CPL	05/05/25	15
6	GB	Form as per Dwg D3330	CPL	05/05/26	15
7	QC5	Inspect work to Step 6	M	05/05/26	15
8	ST	Identify and Stock	CPL	05/05/26	15
9	AC	Cost / part: <u>14.26</u>	SAC	05-05-31	15
10	DC	Close W/O <u>13.72</u> Inspect Level 21	PF	05.06.03	15

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05-01-17

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

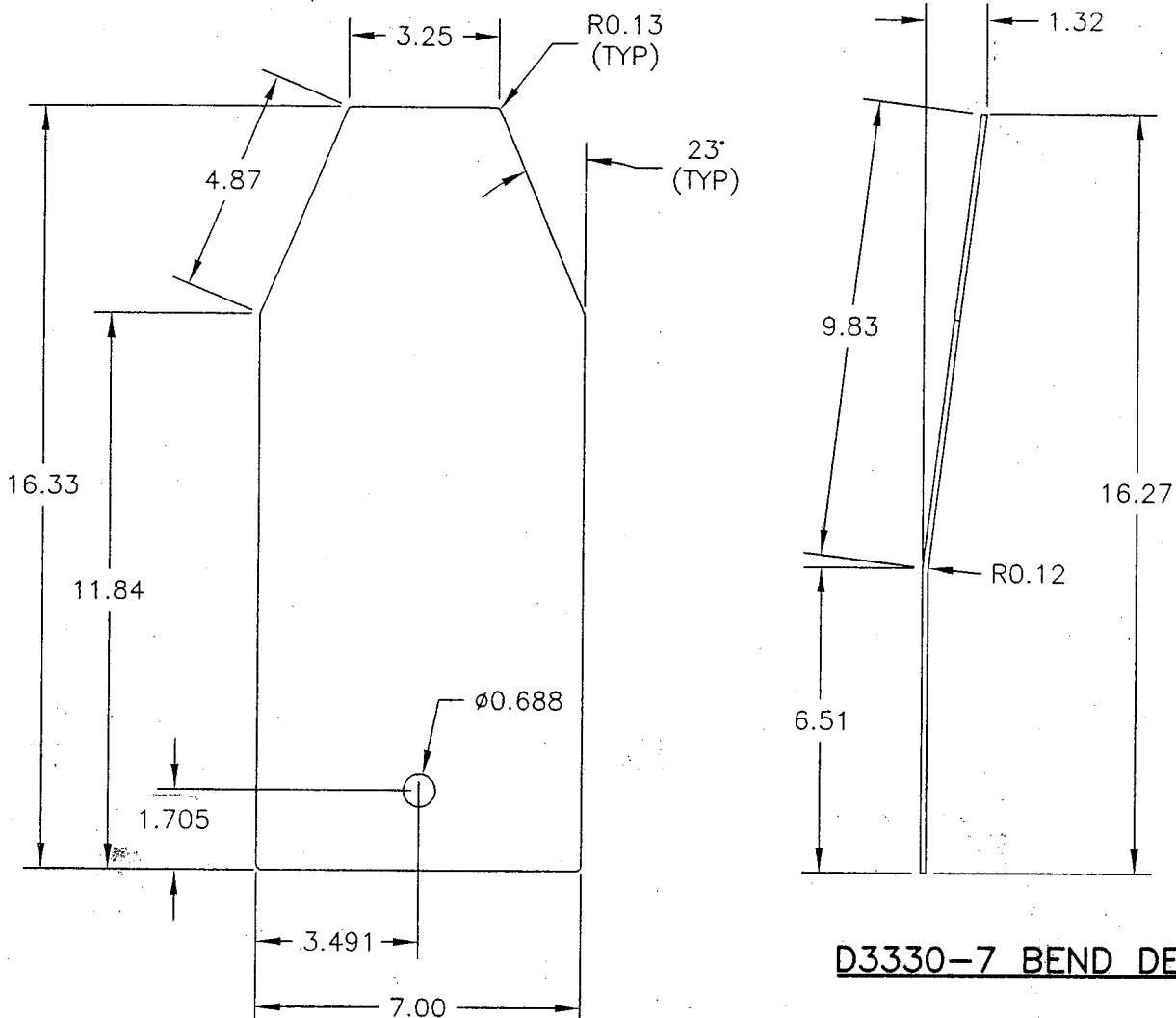
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**PRELIMINARY ISSUE**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3330	SHEET 6 OF 9

DATE
05.02.26TITLE
FRAME ASSEMBLYSCALE
1:4**D3330-7 BEND DETAIL****FLAT PATTERN****SHOP COPY****RETURN TO
ENGINEERING****UNCONTROLLED COPY****AMENDMENT
NOTICE****WORK ORDER****NO. 23052****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21-2002
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK)
NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Job Costing Report

Dart Aerospace Ltd.
HawkesburyApr 12, 2005
02:25 pm

Work Order No : 0023052
 Project Name : D3330-7
 Project For : WK520
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3330-7
 Description : Panel
 Manufactured : Yes
 Amount Req'd : 15
 Amount Done : 0
 Start Date : 04-12-05
 Est Finish Date : 05-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00



BHP New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 3758 999 Auckland
(09) 2358 089 Wauku
Fax: (09) 3758 959 Telex: 24936

TEST CERTIFICATE

Ref. 985/2301

CUSTOMER		Wilkinson	P00821MEOO1	SPECIFICATION												ASTMA569			CERTIFICATE No					
CUSTOMER O/N		90-31N-067	PRODUCT												HOT ROLLED PICKLED & OILED			PAGE						
MILL O/		256321	DIMENSIONS												0.119" x 48" x Coil			DATE						
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																		MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)				
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r ()	LENGTH (feet)
		x100		x1000												x10000		x100	180°					
HP-720792-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						820
HP-720793-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						827
HP-720794-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						817
HP-720795-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						830
HP-720796-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						807
HP-720797-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						810

11 GA

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 √ So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45) / 4	IMPACT TEST (A) x 10mm x 10mm (B)=7.5mm x	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra
QC METALLURGIST